

Date: Monday, 8/13/2007 1:12:19 PM  
 User: Jean-Luc Menard

## Process Sheet

|                       |  |                  |                         |
|-----------------------|--|------------------|-------------------------|
| Customer              | : CU-DAR001 Dart Helicopters Services                      | Drawing Name     | : 206 EXTRUSION BENDING |
| Job Number            | : 33879  |                  |                         |
| Estimate Number       | : 10311  |                  |                         |
| P.O. Number           | : N/A  | Part Number      | : D2620                 |
| This Issue            | : 8/13/2007  | Drawing Number   | : D2620 REV B           |
| Prsht Rev.            | : NC   | Project Number   | : N/A                   |
| First Issue           | : N/A  | Drawing Revision | : B                     |
| Previous Run          | : 32754  | Material         | : N/A                   |
| Written By            | : <i>[Signature]</i> 07-08-13                              | Due Date         | : 8/20/2007             |
| Checked & Approved By | :  | Qty:             | 20 Um: Each             |
| Comment               | : Est. D 02.07.26 Change Dwg to rev.B; Updated Location RF |                  |                         |

## Additional Product

Job Number:



|         |                       |               |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

|     |           |                        |
|-----|-----------|------------------------|
| 1.0 | D26001160 | Extrusion Round 3" 206 |
|-----|-----------|------------------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)

Extrusion Round 3" 206

Pick;

|     |             |                       |        |
|-----|-------------|-----------------------|--------|
| Qty | Part Number | Description           | Batch  |
| 1   | D2600-1     | Extrusion Round 3"206 | B30249 |

21

|     |                |                         |
|-----|----------------|-------------------------|
| 2.0 | LANDING GEAR 1 | LANDING GEAR RESOURCE 1 |
|-----|----------------|-------------------------|



Comment: LANDING GEAR RESOURCE 1

1-Bend extrusion as per Dwg D2620 using CNC Bending Machine program 206.A and Folio Ft008

2- Cut Fwd end of tube as per Dwg D2620

DP 7-8-14

|     |     |                              |
|-----|-----|------------------------------|
| 3.0 | QC5 | INSPECT WORK TO CURRENT STEP |
|-----|-----|------------------------------|



PTO

Comment: INSPECT WORK TO CURRENT STEP

20

|     |             |                       |
|-----|-------------|-----------------------|
| 4.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 46

DP 7-8-22

|     |      |                              |
|-----|------|------------------------------|
| 5.0 | QC21 | FINAL INSPECTION/W/O RELEASE |
|-----|------|------------------------------|



Comment: FINAL INSPECTION/W/O RELEASE

20  
 DP 07/08/23

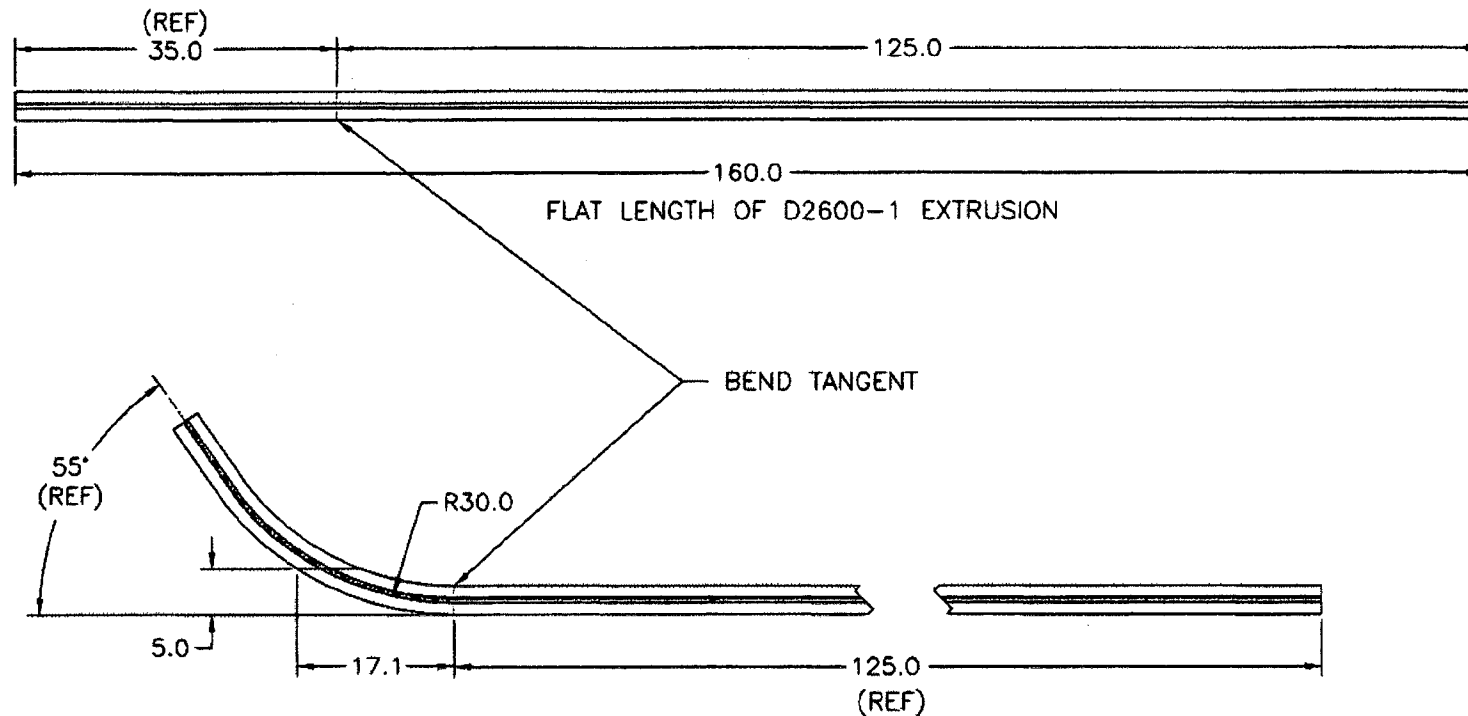
Job Completion



4 07-08-23

# SPECIFICATION CONTROL DRAWING

## 206 SKIDTUBE BENDING



### DAMAGE TOLERANCE

1. THERE SHOULD BE NO VISIBLE WRINKLES BELOW 5.0 AFTER BENDING.
2. GOUGES UP TO 0.020 DEEP ARE ACCEPTABLE IN BENT PORTION OF THE TUBE. NO GOUGES ARE ACCEPTABLE IN THE FLAT PORTION OF THE TUBE. DEEPER GOUGES ARE ACCEPTABLE IN THE PORTION OF THE TUBE ABOVE 5.0.
3. TUBE WIDTH SHOULD BE  $3.20 \pm 0.200$  IN THE BEND. TUBE WIDTH SHOULD BE  $3.200 \pm 0.010$  IN THE FLAT PORTION OF THE TUBE.
4. TUBE HEIGHT SHOULD BE  $3.15 \pm 0.200$  IN THE BEND. TUBE HEIGHT SHOULD BE  $3.150 \pm 0.010$  IN THE FLAT PORTION OF THE TUBE.

NOTE: ALL DIMENSIONS ARE IN INCHES



|          |          |                                     |
|----------|----------|-------------------------------------|
| DESIGN   | DRAWN BY | DART AEROSPACE USA, INC.            |
| CHECKED  | APPROVED | FAIRCHILD INTERNATIONAL AIRPORT, WA |
| DATE     | DATE     | TITLE                               |
| 99.09.10 | 97.11.07 | D2620                               |
| A        | 97.09.10 | 206 SKIDTUBE BENDING CONTROL        |
| B        |          | NEW ISSUE                           |
|          |          | UPDATE FOR IN-HOUSE BENDING         |
|          |          | SCALE                               |
|          |          | 1:20                                |
|          |          | SHEET 1 OF 1                        |
|          |          | REV. B                              |

RELEASED  
99.09.15 DS

# Dart Aerospace Ltd

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: PD Date: 07/08/22  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR:     |      | WORK ORDER NON-CONFORMANCE (NCR)  |                             |                                 |                     |                           |                       |                          |
|----------|------|---|-----------------------------|---------------------------------|---------------------|---------------------------|-----------------------|--------------------------|
| DATE     | STEP | Description of NC<br>Section A  | Corrective Action Section B |                                 |                     | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|          |      |   | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date      |                           |                       |                          |
| 07-08-22 | 3.0  | 1 tube was found with a dent approximately 1/8" in diameter and 0.020" deep. Very visible on the top of the tube, center. R.C: Damage from <del>strapping</del> strapping bundle. | <u>PD</u>                   | scrap & destroy. No replace.    | <u>PD</u><br>7-8-22 | <u>PD</u><br>07-08-22     | <u>PD</u>             | <u>PD</u><br>07-08-22    |
|          |      |   |                             |                                 |                     |                           |                       |                          |
|          |      |   |                             |                                 |                     |                           |                       |                          |

NOTE: Date & initial all entries